

## FTA FIRST Guidelines for Flexography

Image Trap Tolerances										
Wide-Web		Image Trap Tolerances (inches / mm)			Minimum Type Size				Minimum Width of Rule (inches / mm)	
		Process-to-Process	Line-to-Process	Line-to-Line	Positive		Reverse		Positive Rule	Reverse Rule
					Serif	Sans Serif	Serif	Sans Serif		
Preprint Linerboard	SBS Board	± 0.0035 / 0.089	± 0.01 / 0.254	± 0.01 / 0.254	8 pt.	6 pt.	10 pt.	8 pt.	0.01 / 0.254	0.015 / 0.38
Combined Corrugated	Bleached White	± 0.03 / 0.762	± 0.03 / 0.762	± 0.03 / 0.762	8 pt.	6 pt.	10 pt.	8 pt.	0.013 / 0.33	0.02 / 0.51
	Coated Paper	± 0.015 / 0.381	± 0.015 / 0.381	± 0.015 / 0.381	6 pt.	4 pt.	8 pt.	6 pt.	0.007 / 0.18	0.01 / 0.254
Folding Carton	SBS Board	± 0.003 / 0.076	± 0.003 / 0.076	± 0.0075 / 0.1905	6 pt.	4 pt.	8 pt.	6 pt.	0.006 / 0.15	0.008 / 0.20
	CRB Board	± 0.003 / 0.076	± 0.0045 / 0.114	± 0.0055 / 0.14	6 pt.	4 pt.	8 pt.	6 pt.	0.006 / 0.15	0.008 / 0.20
Multiwall Bag	Coated Paper	± 0.0075 / 0.1905	± 0.0175 / 0.444	± 0.0175 / 0.444	8 pt.	6 pt.	12 pt.	10 pt.	0.007 / 0.18	0.01 / 0.254
	Uncoated Paper	± 0.0075 / 0.1905	± 0.015 / 0.381	± 0.03 / 0.762	10 pt.	8 pt.	18 pt.	12 pt.	0.013 / 0.33	0.02 / 0.51
Film Substrates	Polyester	± 0.0075 / 0.1905	± 0.0075 / 0.1905	± 0.0075 / 0.1905	8 pt.	6 pt.	12 pt.	10 pt.	0.007 / 0.18	0.015 / 0.38
	Polypropylene Clear				8 pt.	6 pt.	10 pt.	8 pt.		
	Polypropylene Opaque White				8 pt.	6 pt.	10 pt.	8 pt.		
	Polyethylene Clear				8 pt.	6 pt.	10 pt.	8 pt.		
	Polyethylene Opaque White				8 pt.	6 pt.	10 pt.	8 pt.		
	Metallized				8 pt.	6 pt.	10 pt.	6 pt.		
Narrow-Web		Image Trap Tolerances (inches/mm)			Minimum Type Size				Minimum Width of Rule (inches/mm)	
		Process-to-Process	Line-to-Process	Line-to-Line	Positive		Reverse		Positive Rule	Reverse Rule
					Serif	Sans Serif	Serif	Sans Serif		
Paper Substrates	All	± 0.0045 / 0.114	± 0.005 / 0.13	± 0.005 / 0.13	6 pt.	4 pt.	8 pt.	6 pt.	0.005 / 0.13	0.01 / 0.254
Film Substrates	All	± 0.0045 / 0.114	± 0.005 / 0.13	± 0.005 / 0.13	6 pt.	4 pt.	8 pt.	6 pt.	0.004 / 0.10	0.008 / 0.20

Line Screen/Ruling (LPI)	Min. Bar Code Mag.
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Wide-Web		Line Screen/Ruling (LPI) (lpi / lpcm)			Machine Direction
		Conventional Plates	Digitally Imaged Photopolymer	Laser Engraved	
Preprint Linerboard	SBS Board	110-133 / 43-52	110-175 / 43-69	110-120 / 43-47	100%
	Uncoated Paper	100-133 / 39-52	100-133 / 39-52	100-120 / 39-47	-
Combined Corrugated	Bleached White	55-100 / 22-39	55-100 / 22-39	55-100 / 22-39	UPC: 110%-120% ITF-14: 100%
	Coated Paper	55-110 / 22-43	55-110 / 22-43	85-110 / 33-43	
Folding Carton	SBS Board	120-150 / 47-59	120-175 / 47-69	110-120 / 43-47	100%
	CRB Board	110-133 / 43-52	110-133 / 43-52	110-120 / 43-47	100%
Multiwall Bag	Coated Paper	75-120 / 30-47	75-120 / 30-47	75-110 / 30-43	115%
	Uncoated Paper	65-85 / 26-33	65-100 / 26-39	65-100 / 26-39	115%
Film Substrates	All	110-133 / 43-52	110-150 / 43-59	85-120 / 33-47	100%
Narrow-Web		Line Screen/Ruling (LPI) (lpi / lpcm)			Machine Direction
		Conventional Plates	Digitally Imaged Photopolymer	Laser Engraved	
Paper Substrates	Coated Paper	133-175 / 52-69	133-175 / 52-69	110-120 / 43-47	80%
	Uncoated Paper	110-133 / 43-52	110-133 / 43-52	100-120 / 39-47	-
Film Substrates	All	110-133 / 43-52	110-150 / 43-59	85-120 / 33-47	100%